

52036 607.0411

Work Order ID 53208

Page 1

October 26, 2009 1:02:03 PM

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RP*Date: *09-10-26*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: *1* 0.00

Large Fab

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 *SAD 09-14-04*
 2-Cut (4) D2236 From D3166-3
 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
 4-Weld as per Dwg D2512 using Welding Jig DT 9436
 Deburr as required
 INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

*Cpl 09 11 05**PD 09.11.04 09.10*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

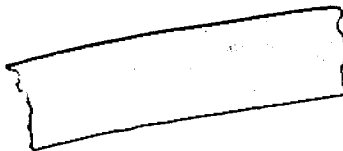


QC

Memo

0.00

Quality Control

11/11/06

Work Order ID 53208

October 26, 2009 1:02:03 PM



Page 2

Item ID:	D2512	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Basket Lid 205/350					
Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat									
Powder Coating									

Memo *pressure wash 11/09/11/09
 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat
 M112148
 1ST COAT:
 START TIME: 8:30AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 9:00AM
 2ND COAT:
 START TIME: 9:15AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 9:45AM

Work Order ID 53208

October 26, 2009 1:02:03 PM



Page 3

Item ID:	D2512	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Basket Lid 205/350					
Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	HandFinishing	0.00				(IX)			
HandFinish	Memo	0.00							
Hand Finishing	Wing Walk and Spray Paint black as per Dwg D2512 and QS1 005 4.4 Batch: <u>MH2106</u>								
150 	QC3- Inspect Part Finish	0.00				①			
QC	Memo	0.00							
Quality Control									
160 	Identify as per dwg & Stock Location: <u>W10 53197</u>	0.00							
Packaging	Memo	0.00							
Packaging									

7M-1
09/11/09

BR 09-11-10

W10 53197

PPP

10/11/10

Work Order ID 53208

October 26, 2009 1:02:03 PM

Page 4

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/11 *[Signature]*
MF
09-11-11

Picklist Print

October 26, 2009 1:02:07 PM

Page 1

Work Order ID: 53208

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	24.0000	2.0000			

Clevis

Handwritten:
A MF
09-11-11

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	24	
31101	2	
52498	22	

ONLY APPLICABLE ON D130-701-117

D2232-1RevC

Manufactured No



Basket Hinge

100 Each 26.0000 2.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	24	
50896	4	
51105	20	

Handwritten: 2 PD 09-11-04

Handwritten: 6/2 09-10-04

Picklist Print

October 26, 2009 1:02:07 PM

Work Order ID: 53208



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-1RevD

Manufactured

No

100

Each

41.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

51331

16

52832

25

PD 09.11.04

D2506RevF

Manufactured

No

100

Each

13.0000

1.0000



Label Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

12

51303

2

52834

10

CPL 09.11.04

Picklist Print

Page 3

October 26, 2009 1:02:07 PM

Work Order ID: 53208



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	66.0000	2.0000			
✓												
Mounting Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	53	
50872	4	
51745	49	

D3166-3RevA1

Manufactured No



Basket Hoop

100 Each 11.6210 1.0000



26/10/09-11-04

SAD 09-11-09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	11.621	
50033	0.0527	
50618	0.5683	
51249	5	
52058	6	

October 26, 2009 1:02:07 PM

Shop Packet Print

Page 3

Picklist Print

October 26, 2009 1:02:07 PM

Work Order ID: 53208

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304EX0.75-16F Purchased

No

100

sf

476.5700

18.9474



Expanded Metal Flat SS

SAD 09-10-04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

476.570065

110134

3.4

111630

5.85

111956

0.000017

112147

8.29428947

112311

28.9205

112707

110.1052

112949

320

2.00

16.9474

M304TS0.750W.065

Purchased

No

100

f

460.8319

45.8741



304 SQ Tube .75x.75x.065W

SAD 09-11-05

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

460.8318947

112398

460.831895

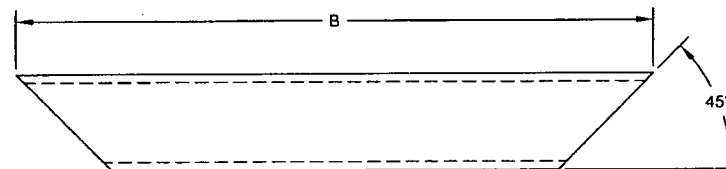
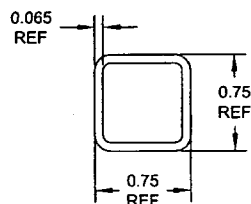
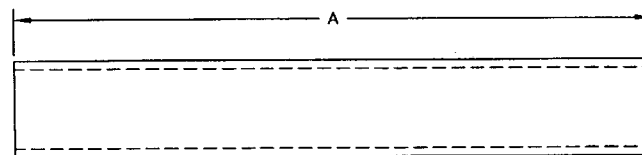
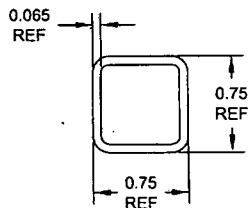
45.8741

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53208

PL 09-10-26



RELEASED

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- D2512-1/-3/-5/-7 NOTES:**
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY

RETURN TO

ENCLOSURE

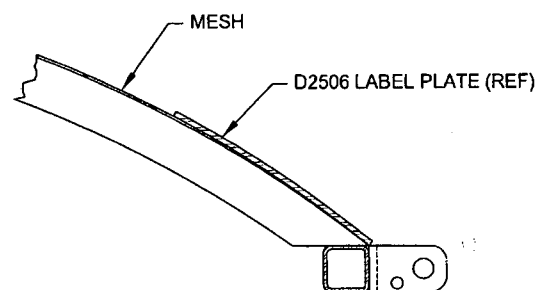
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 53208



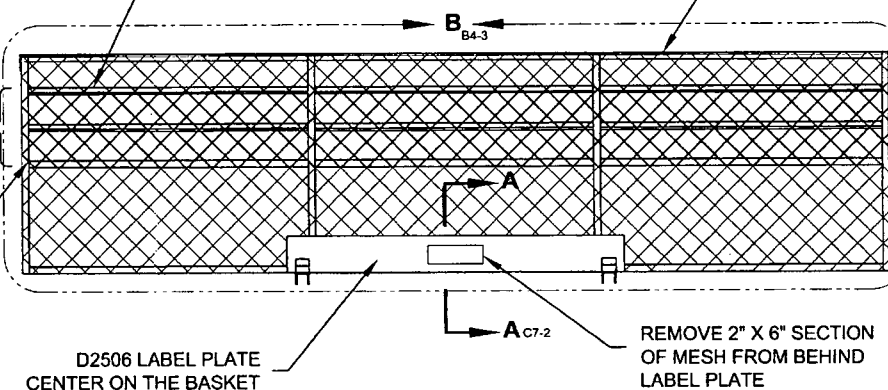
SECTION A-A_{B3-2} (ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

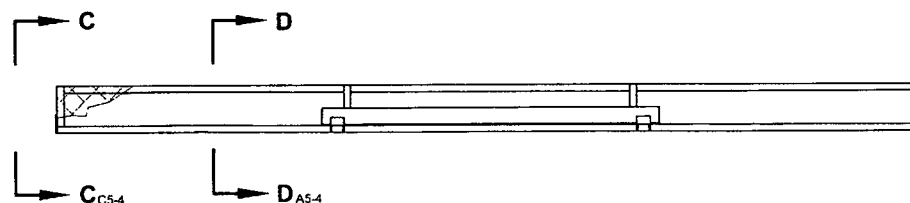
SEE DETAIL B FOR
FRAME ASSEMBLY




E

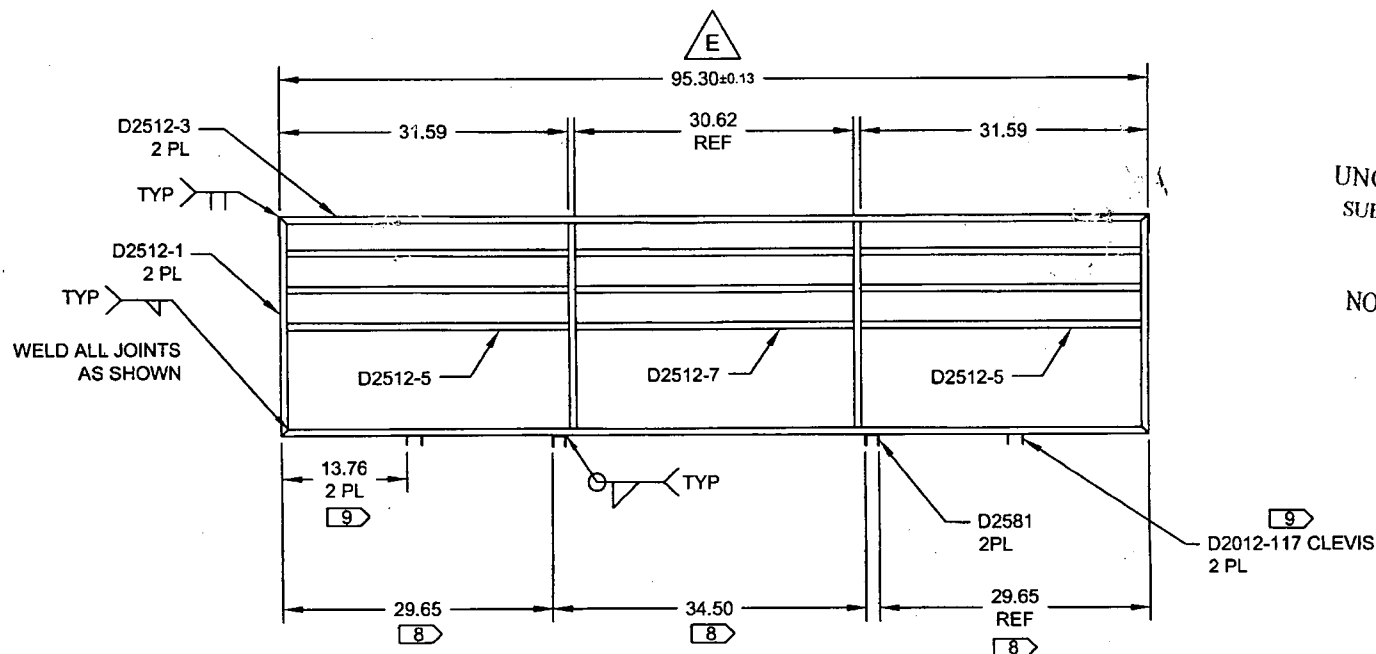
D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

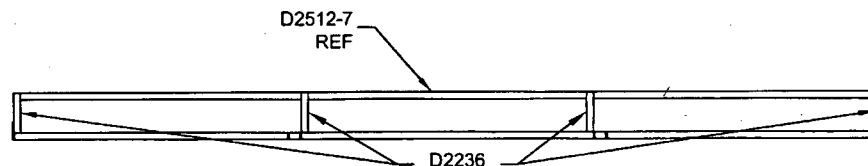
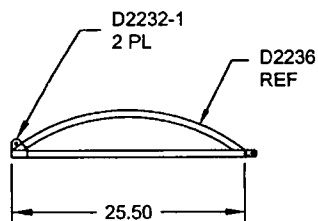


RELEASED

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *PL 09-10-24*
53208

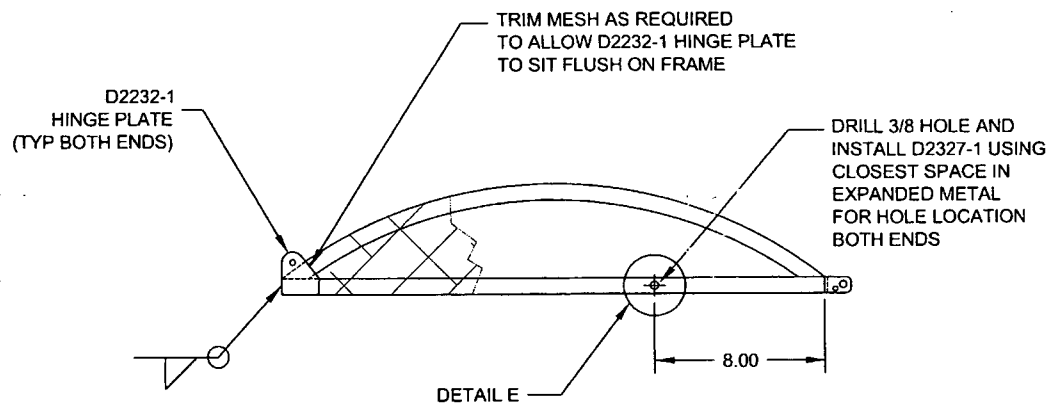
RELEASED
08-06-17

OTES:

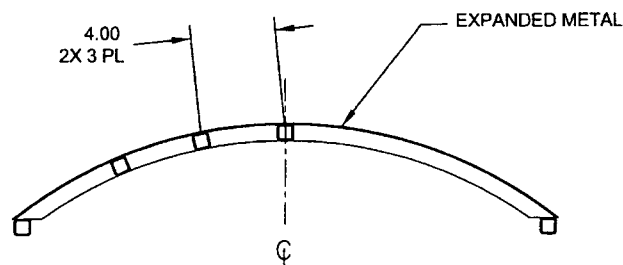
- MATERIAL: NONE
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: NONE
- WEIGHT: N/A
- LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

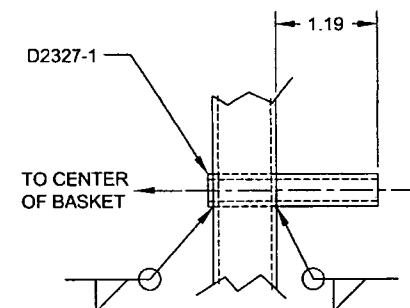


VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ONLY
NO. 53208



DETAIL E C6-4

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1